

Work Order ID 119947

May-30-14 9:20:14 AM

\*119947\*

Page 1

Item ID: D3890-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Gasket

Start Date: 5/30/14

Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 5/30/14

Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 14-05-30

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3890

A

100

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3890

Dwg Rev: A

Prog Rev: A

M4111 .125

FOAM.

2-Deburr if necessary

2

0

Jm14-05-30

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

2

0

Jm14-05-30

Work Order ID 119947

May-30-14 9:20:14 AM

\*119947\*

Page 2

Item ID: D3890-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Gasket

Start Date: 5/30/14 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

\*120\*

DAS

27

9-89

0.00

QC

Memo

Quality Control

14/5/30

130

Identify as per dwg & Stock Location: GA

0.00

\*130\*

DAS

30

9-89

Packaging

Memo

0.00

Packaging

2

14/05/30

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

MLJ 14-06-02

mf 14-5-30

# Picklist Print

May-30-14 9:20:16 AM

Page 1

Work Order ID: 119947

**\*119947\***

Parent Item: D3890-3

**\*D3890-3\***

Parent Item Name: Gasket

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4111NS.125

Purchased

No

100

sf

176.7200

0.026

(1)

**\*M4111NS 125\***

\*\*

Jm14-05-30

4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

Location

Loc Qty

Loc Code

MAT052

176.72

m127905

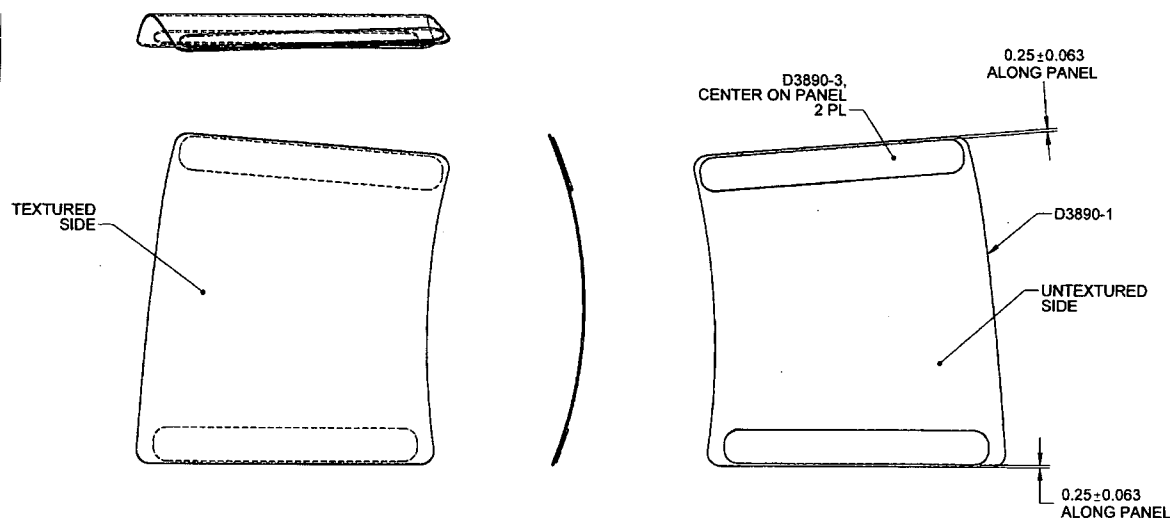
176.72

127905



# PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3890-041	PANEL, SIDE
2	1	D3890-1	PANEL
3	2	D3890-3	GASKET
5	A/R	3M 1300	ADHESIVE



**D3890-041 PANEL, SIDE**

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3890-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.48 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 119947 MLC

14-05-30

**RELEASED**  
09/05/16

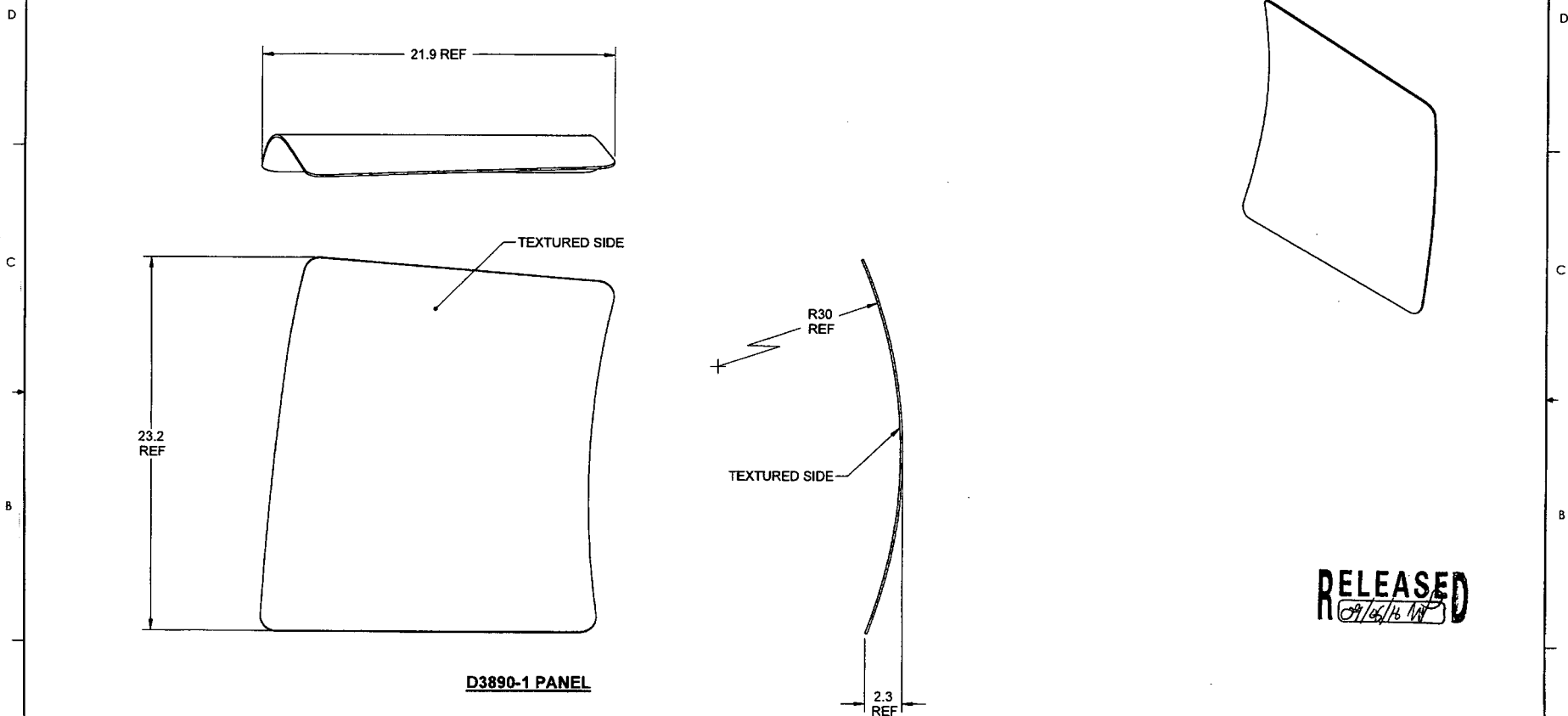
A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	92		
DRAWN	92		
CHECKED	PH		
MFG. APPR.	21		
APPROVED	21		
DE APPR.	21		
DATE	09.05.01		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3890** REV. A  
SHEET 1 OF 4  
TITLE **PANEL, SIDE** SCALE NTS

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8 7 6 5 4 3 2 1

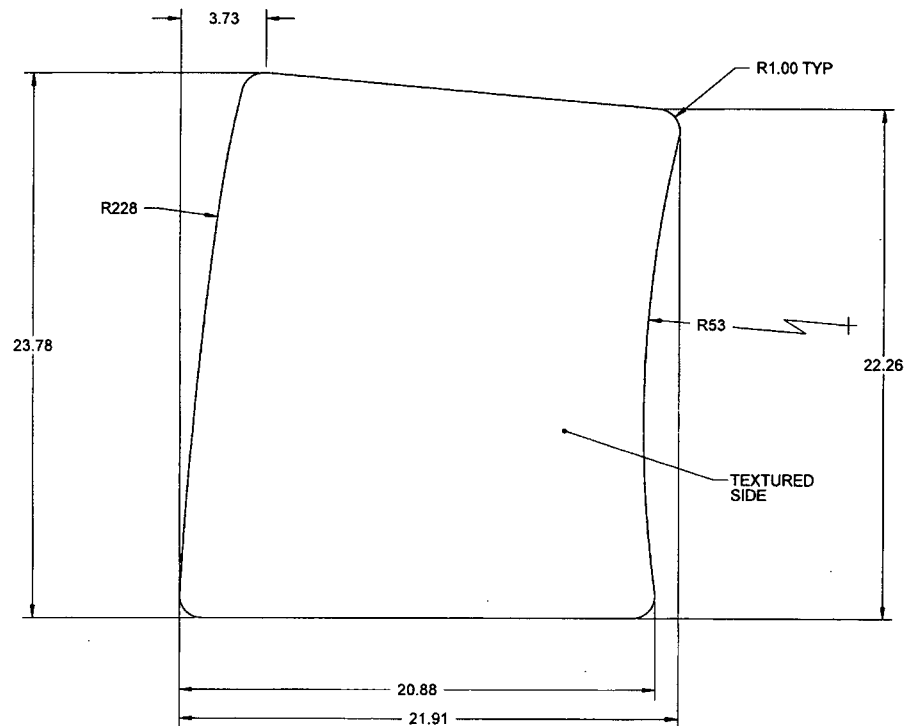


**NOTES:**

- 1) MATERIAL: MAKE FROM D3890-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.45 lbs
- 8) THERMOFORM USING MOLD DT9489 PER QSI 022

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3890	SHEET 2 OF 4
APPROVED	12	TITLE	SCALE
DE APPR.	12	PANEL, SIDE	NTS
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8 7 6 5 4 3 2 1



**D3890-1F PANEL**

**RELEASED**  
9/06/16

**NOTES:**

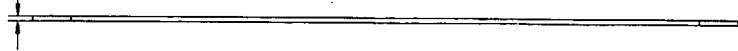
- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.45 lbs

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CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3890	SHEET 3 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	PANEL, SIDE	NTS
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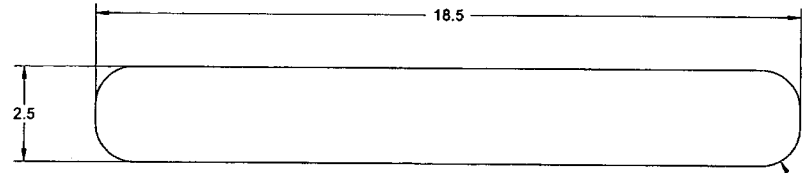
8 7 6 5 4 3 2 1

D D

0.125  
REF



C C



R1.0  
TYP

**D3890-3 GASKET**

B B

**RELEASED**  
09/06/11

**NOTES:**

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK  
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3890	SHEET 4 OF 4
APPROVED	12	TITLE	SCALE
DE APPR.	21	PANEL, SIDE	NTS
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8 7 6 5 4 3 2 1